

Date: Monday, 04/05/2009 1:45:08 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	VERTICAL TUNNEL KIT
Job Number :	47672		
Estimate Number :	13685		
P.O. Number :		Part Number :	D206781151KGY
This Issue :	04/05/2009	Drawing Number :	D206-781-151
Prsht Rev. :	NC	Project Number :	
First Issue :	/ /	Drawing Revision :	B
Previous Run :	47304	Material :	
Written By :		Due Date :	11/05/2009
Checked & Approved By :	JLD 09/05/04	Qty:	1
Comment :	Est. Rev. A 08/12/08 New Issue DL Est. Rev. B 09/04/15 Dwg. Update: DL verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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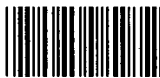


Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-781-151 CHG001



2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit



3.0	47672A	VERTICAL TUNNEL L/H
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Comment: Sub-Component VERTICAL TUNNEL L/H

D 3822-1



4.0	47672B	VERTICAL TUNNEL R/H
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Comment: Sub-Component VERTICAL TUNNEL R/H

D 3822-2



5.0	47672C	VERTICAL TUNNEL AFT CENTER
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Comment: Sub-Component VERTICAL TUNNEL AFT CENTER

D 3822-3



6.0	47672D	VERTICAL TUNNEL TOP
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Comment: Sub-Component VERTICAL TUNNEL TOP

D 3822-5



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/05/2009 1:45:08 PM
User: Linda Lacelle

Process Sheet

080

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL KIT

Job Number: 47672

Part Number: D206781151KGY

Job Number:



Seq. #: Machine Or Operation: Description :

7.0 47672E VERTICAL TUNNEL LOWER

570



52

Comment: Sub-Component VERTICAL TUNNEL LOWER

D3822-7

8.0 D38001100 Hook and Loop Strip (1" Soft)



Comment: Qty.: 1.3330 f(s)/Unit Total: 1.3330 f(s)
Hook and Loop Strip (1" Soft)

5

Cut D3800-1-100-800 Qty 2

measured 8 1/2" x 25 80"

44830

88 09/05/25 (X)

9.0 D38003100 Hook and Loop Strip (1" Hard)



Comment: Qty.: 1.3330 f(s)/Unit Total: 1.3330 f(s)
Hook and Loop Strip (1" Hard)

5

Cut D3800-3-100-800 Qty. 2

measured 8 1/2" x 25 80"

1344831

88 09/05/25 (X)

10.0 NAS38868P Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Screw

5

M111439

88 09/05/25 (X)

11.0 NAS388612P Screw



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)
Screw

5

M11542x2. M111310x12

88 09/05/25 (X)

12.0 NAS391B6P Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)
Washer

5

M110221

88 09/05/25 (X)

13.0 ALS463280 Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Insert

5

M17841

88 09/05/25 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/05/2009 1:45:08 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL KIT

Job Number: 47672

Part Number: D206781151KGY

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

ALS4632130

Insert



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Insert M110452

8/09/05/25 (X)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5/09/05/26 (X)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-781-151

Location:

PPP-Rev: ~~7/09/05/26~~

Draft

9/5/06

(R)
SE

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26 (X)

Job Completion



6/09/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

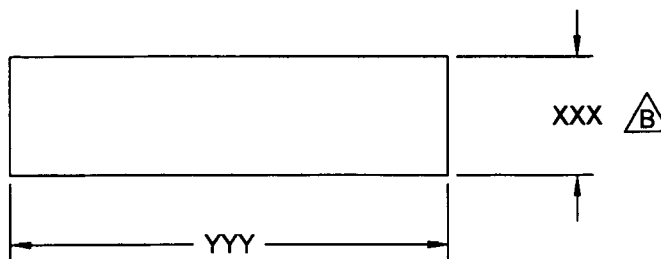
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



DESCRIPTION: HOOK AND LOOP STRIP WITH ADHESIVE BACK

SPECIFICATION: D3800-1-XXX-YYY LOOP STRIP (ie. SOFT VELCRO STRIP) B
 D3800-3-XXX-YYY HOOK STRIP (ie. HARD VELCRO STRIP) B

WHERE 'XXX' IS WIDTH IN HUNDREDTHS OF AN INCH
 AND 'YYY' IS LENGTH IN TENTHS OF AN INCH

EG. 1" WIDE BY 2.5" LONG LOOP STRIP = D3800-1-100-025
 2" WIDE BY 10.0" LONG HOOK STRIP = D3800-3-200-100

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 47672

PART NUMBER	WIDTH	PURCHASE
D3800-1-100-YYY LOOP STRIP	1.0	McMASTER CARR P/N: 9776K122, 9776K126, 9776K18, 9776K28, 9776K131, 9776K38
D3800-3-100-YYY HOOK STRIP	1.0	McMASTER CARR P/N: 9776K97, 9776K113, 9776K13, 9776K23, 9776K117, 9776K33
D3800-1-100-YYY & D3800-3-100-YYY (PURCHASED AS COMBINATION PACK)	1.0	McMASTER CARR P/N: 9776K72, 9776K76, 9776K79, 9776K84, 9776K88, 9776K93
D3800-1-200-YYY LOOP STRIP	2.0	McMASTER CARR P/N: 9776K123, 9776K127, 9776K19, 9776K29, 9776K132, 9776K39
D3800-3-200-YYY HOOK STRIP	2.0	McMASTER CARR P/N: 9776K98, 9776K114, 9776K14, 9776K24, 9776K118, 9776K34
D3800-1-200-YYY & D3800-3-200-YYY (PURCHASED AS COMBINATION PACK)	2.0	McMASTER CARR P/N: 9776K73, 9776K77, 9776K81, 9776K85, 9776K89, 9776K94

NOTES:

- 1) MATERIAL: WOVEN NYLON HOOK AND LOOP WITH ADHESIVE BACK
 BEIGE COLOR
 ACCEPTABLE SUPPLIERS PER ABOVE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED

B	ADD 1" WIDTH OPTION, "XXX-YYY" WAS "XXX", ADD ADDITIONAL McMASTER PART NUMBERS	CP	08.09.09
A	NEW ISSUE	CP	08.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>GP</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	D3800	SHEET 1 OF 1
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	HOOK AND LOOP STRIP	NTS
DATE	08.09.09	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

5.0 PARTS LIST

5.1 BELL 206 A/B

D206-781-111/-113/-115/-117 UTILITY KITS

Qty -111	Qty -113	Qty -115	Qty -117	Part Number	Description
X				D206-781-111	UTILITY KIT W/O ROTOR BRAKE
	X			D206-781-113	UTILITY KIT W/ ROTOR BRAKE
		X		D206-781-115	UTILITY KIT W/O ROTOR BRAKE, LITTER KIT COMPATIBLE
			X	D206-781-117	UTILITY KIT W/ ROTOR BRAKE, LITTER KIT COMPATIBLE
1		1		D206-781-141	CREW CABIN OVERHEAD W/O ROTOR BRAKE KIT
	1		1	D206-781-143	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
1	1	1	1	D206-781-151	VERTICAL TUNNEL KIT
1	1	1	1	D206-781-161	REAR OVERHEAD KIT
1	1			D206-781-171	HAT BIN KIT
		1	1	D206-781-173	HAT BIN KIT, LITTER KIT COMPATIBLE

D206-781-141/-143/-151/-161/-171/-173 KITS

Qty -141	Qty -143	Qty -151	Qty -161	Qty -171	Qty -173	Part Number	Description
X						D206-781-141	CREW CABIN OVERHEAD W/O ROTOR BRAKE KIT
	X					D206-781-143	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
		X				D206-781-151	VERTICAL TUNNEL KIT
			X			D206-781-161	REAR OVERHEAD KIT
				X		D206-781-171	HAT BIN KIT
					X	D206-781-173	HAT BIN KIT, LITTER KIT COMPATIBLE
1						D3821-1	PANEL - W/O ROTOR BRAKE
	1					D3821-3	PANEL - W/ ROTOR BRAKE
4	4					NAS388-6-8P	SCREW
4	4					NAS391B6P	WASHER
		1				D3822-1 ✓	VERTICAL TUNNEL, LH
		1				D3822-2 ✓	VERTICAL TUNNEL, RH
		1				D3822-3 ✓	VERTICAL TUNNEL, AFT CENTER
		1				D3822-5 ✓	VERTICAL TUNNEL, TOP
		1				D3822-7 ✓	VERTICAL TUNNEL, LOWER
		2				D3800-1-100-800	LOOP STRIP
		2				D3800-3-100-800	HOOK STRIP
		4				NAS388-6-8P	SCREW
		14				NAS388-6-12P	SCREW
		18				NAS391B6P	WASHER
		4				ALS4-632-80	INSERT
		8				ALS4-632-130	INSERT
			1			D3823-1	REAR OVERHEAD, LH
			1			D3823-2	REAR OVERHEAD, RH
			1			D3823-3	REAR OVERHEAD, CENTER
			10			AN525-10R24	SCREW
			10			NAS43DD3-68	SPACER

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Revision: B

Date: 09.02.19

w/o
47672

				1		D3824-1	HAT BIN
					1	D3824-3	HAT BIN
				6	6	D3851-1	DOUBLER
				4	4	AN525-10R10	SCREW

5.2 BELL 206 L/L1

Qty -371	Part Number	Description
X	D206-781-371	HAT BIN KIT
1	D3845-1	HAT BIN
6	D3851-1	DOUBLER
4	AN525-10R14	SCREW

5.3 BELL 206 L3/L4

Qty -571	Part Number	Description
X	D206-781-571	HAT BIN KIT
1	D3850-1	HAT BIN
6	D3851-1	DOUBLER
4	AN525-10R8	SCREW

5.4 BELL 407

Qty -771	Part Number	Description
X	D407-781-771	HAT BIN KIT
1	D3835-1	HAT BIN
4	D3851-1	DOUBLER
2	AN525-10R7	SCREW

47672